

Work Order ID 71171

Thursday, June 23, 2011 11:14:51 AM



Page 1

Item ID: D2647

Accept



Setup Start



Revision ID:

Stop



Item Name: Cap

Start Date: 6/23/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

CL

Date: 11/06/23

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D2647	Rev F								

100 0.00

Waterjet
 FLOW CNC Waterjet
 6061 . 080
 FLOW WATER JET
 Memo
 1-Cut as per Dwg D2647
 Dwg Rev: F
 Prog Rev: F
 2-Deburr if necessary
 0.00
 RB11-6-29
 34

110 0.00

QC
 Quality Control
 QC2- Inspect parts off machine FAI/FAIB
 Memo
 0.00
 RB11-6-29

120 0.00

QC
 Quality Control
 QC8- Inspect parts - second check
 Memo
 0.00
 8/10/30
 canto
 +30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71171

Thursday, June 23, 2011 11:14:51 AM



Page 2

Item ID: D2647

Accept



Setup Start



Revision ID:

Stop



Item Name: Cap

Start Date: 6/23/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Small Fab	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Deburr								
140 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
150 Packaging	Identify as per dwg & Stock Location: <u>UA</u>	0.00							
Packaging	Memo	0.00							
	STOCK IN SKIDTUBE CELL								

D/AO

11/4/4 SP (300)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71171

Thursday, June 23, 2011 11:14:51 AM



Page 3

Item ID: D2647

Accept



Setup Start



Revision ID:

Stop



Item Name: Cap

Start Date: 6/23/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/4 *[Signature]*

CL11107104

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, June 23, 2011 11:14:49 AM

Page 1

Work Order ID: 71171



Parent Item: D2647

Parent Item Name: Cap

Start Date: 6/23/2011

Required Date: 6/30/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:D□99.01.25□Re-format□DM
IPP: E 06.11.15 waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No			100	sf	256.5000	0.1597	3.362105			

6061-T6 .080 Sheet

Location

Loc Qty

Loc Code

MAT021

256.5

116268

33.5

117285

223

117285

30

B11-6-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

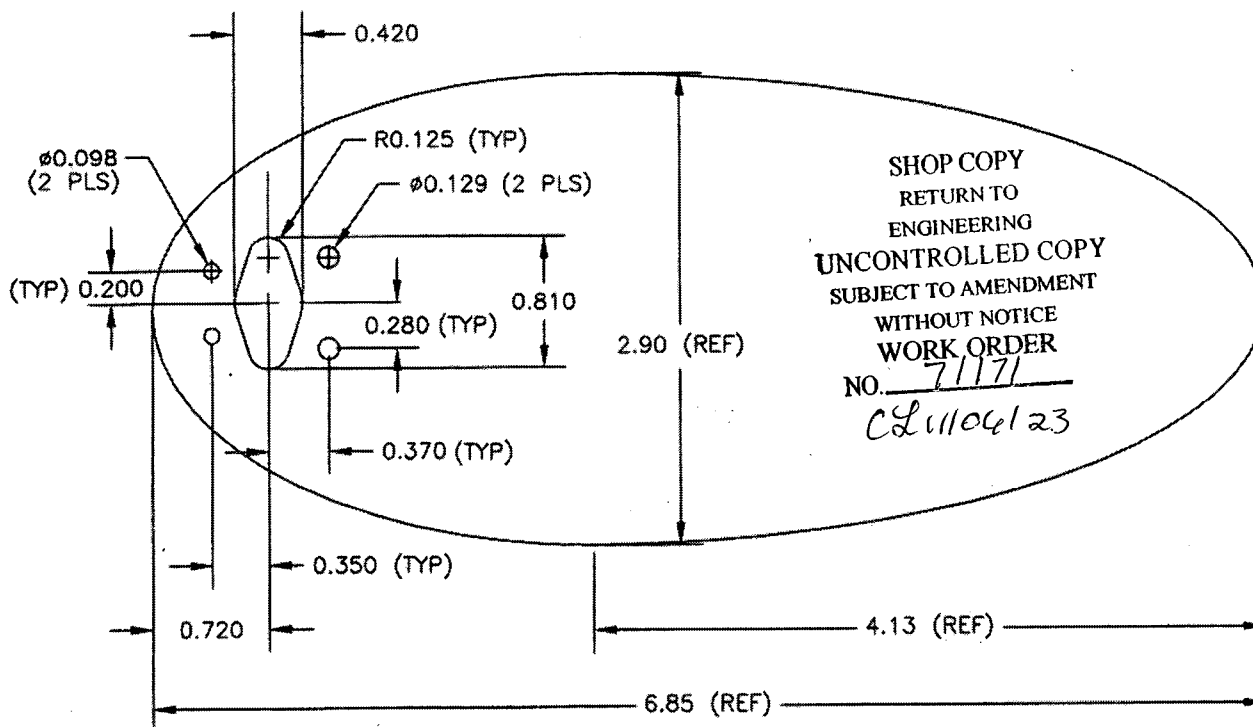
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN #	DRAWN BY RT	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED #	APPROVED #	DRAWING NO. D2647	REV. F SHEET 1 OF 1
DATE 00.05.26		TITLE CAP	SCALE NTS
A	97.03.25	NEW ISSUE	
B	97.06.27	CHANGED SHAPE	
C	97.09.15	REMOVE FRONT PLATE	
D	97.11.06	ADD RIVET HOLES	
E	98.01.15	ADD 5052 MATERIAL (TSR A245)	
F	00.05.26	MAKE FROM D2794	

RELEASED
00.06.09



THIS PART CAN BE MADE FROM D2794

MATERIAL: 6061-T6 (QQ-A-250/11) OR
5052-H32 (QQ-A-250/8) 0.080 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright © 1997 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

DART AEROSPACE LTD		Work Order:	71171
Description: Cap		Part Number:	D2647
Inspection Dwg: D2647 Rev: F		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	.102	>		V B02	
Ø0.129	+0.005/-0.001	.130	>		V	
0.420	+/-0.010	.423	>		V	
0.810	+/-0.010	.814	>		V	
0.350	+/-0.010	.356	>		V	
0.720	+/-0.010	.720	>		V	
0.370	+/-0.010	.370	>		V	
2.90	+/-0.030	2.904	x		V	
6.85	+/-0.030	6.844	>		V	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 11-6-09	Date: 11/09/30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.11.26	New Issue	KJ/EC/DD	
B	09.03.10	0.370 dimension removed	KJ/DD	